

Wednesday, 5/23/2007 3:25:13 PM
Kim Johnston

Process Sheet

SPIT.

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY
 Job Number : 32479 -1
 Estimate Number : 10774
 P.O. Number : NIA
 This Issue : 5/23/2007 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NIA Type : LARGE FAB ASSY
 Previous Run : 30306
 Written By :
 Checked & Approved By : 07.05.24
 Comment : Est A 05.09.13 New issue KJ/JLM

Part Number : D3414041
 Drawing Number : D3414 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : NIA
 Due Date : 6/10/2007 Qty: 20 Um: Each

11 07/07/25

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S12GA 304/316 .100" Sheet



Comment: Qty.: 0.1523 sf(s)/Unit Total : 3.0450 sf(s)
 304/316 stainless steel 0.100" Sheet
 Batch: M105130

SAD 07/07/25

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3414
 Dwg Rev: A
 Prog Rev: A

SAD 07/07/25

2-Deburr if necessary

(30)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/07/25

(30)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07/07/26

(30) counter

5.0 BRAKE NC NC BRAKE

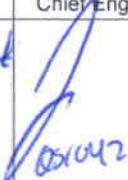
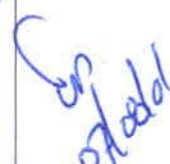




Comment: NC BRAKE
 Deburr
 Form using DT8254 as per Dwg D3414

FF 07-08-01 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-01	5	1 Lug Assembly bracket Due to marking on Press brake. RC: setup error.	 05/04/02	Scrap + Destroyed Not Replaced.	07/08/01 FF	 07/08/01	 05/04/02	 07/08/01

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 32479

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/01 (125)

7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Lug

Pick:

Qty

Part Number Description Batch

1

D3414-3

Lug

B32516
M102420

A/R SS Rod

SS 07/08/02

(11x)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

SS 07/08/02

(11x)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SS 07/08/02 (16)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 07/08/02 (11)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105068

M-L 07/08/07
PRESSURE WASH BR 07/08/07

(11x)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P-7/15/8 (11)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST475 P-7/15/8 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 32479

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207108/09 (11)

Job Completion



CY 07/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

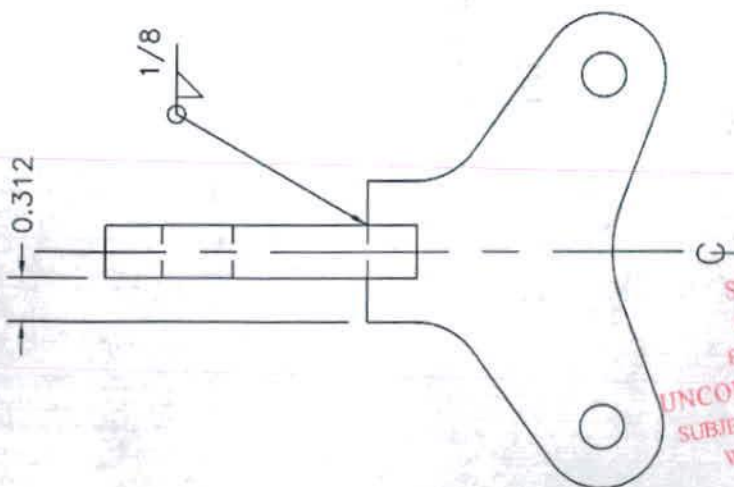
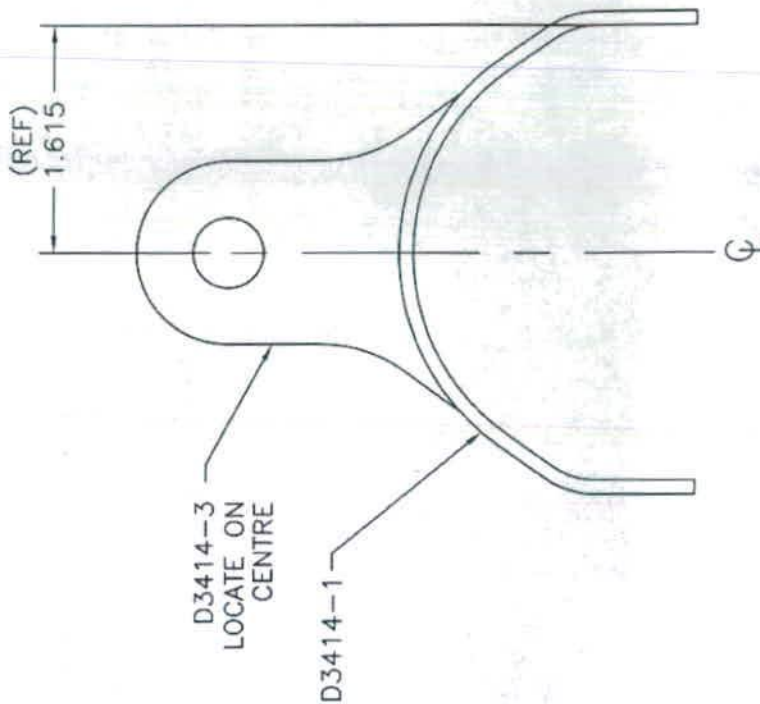
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 1 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	

RELEASED
05-04-06 *[Signature]*

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NO. 32479

D3414-041 LUG ASSEMBLY

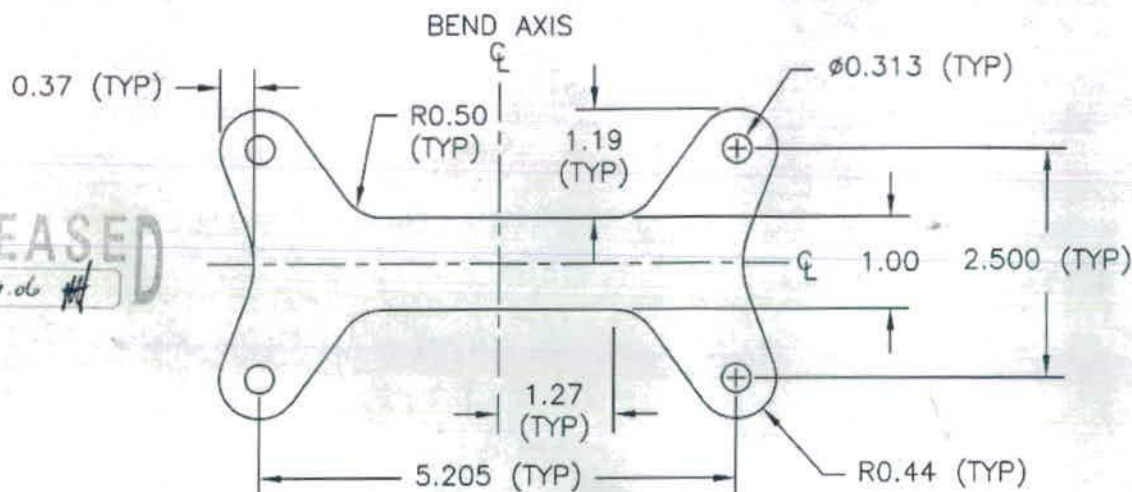
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

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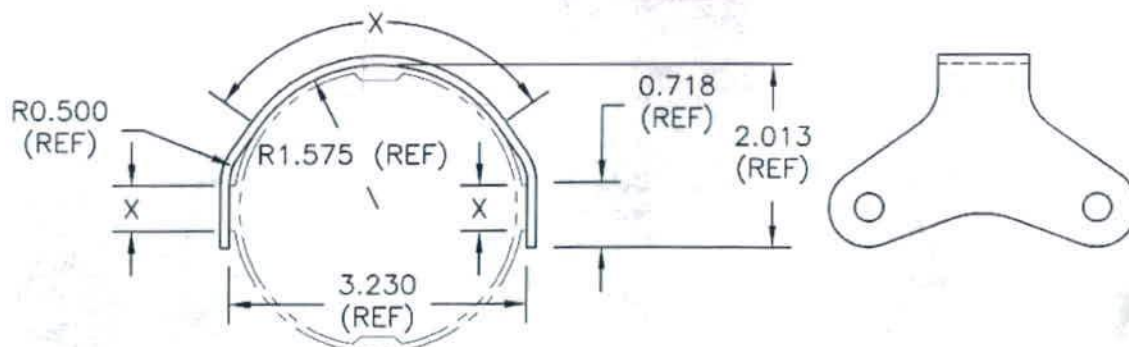
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DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2

RELEASED
05.09.06 *[Signature]***D3414-1 FLAT PATTERN**

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)

**D3414-1 BEND DETAIL**

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

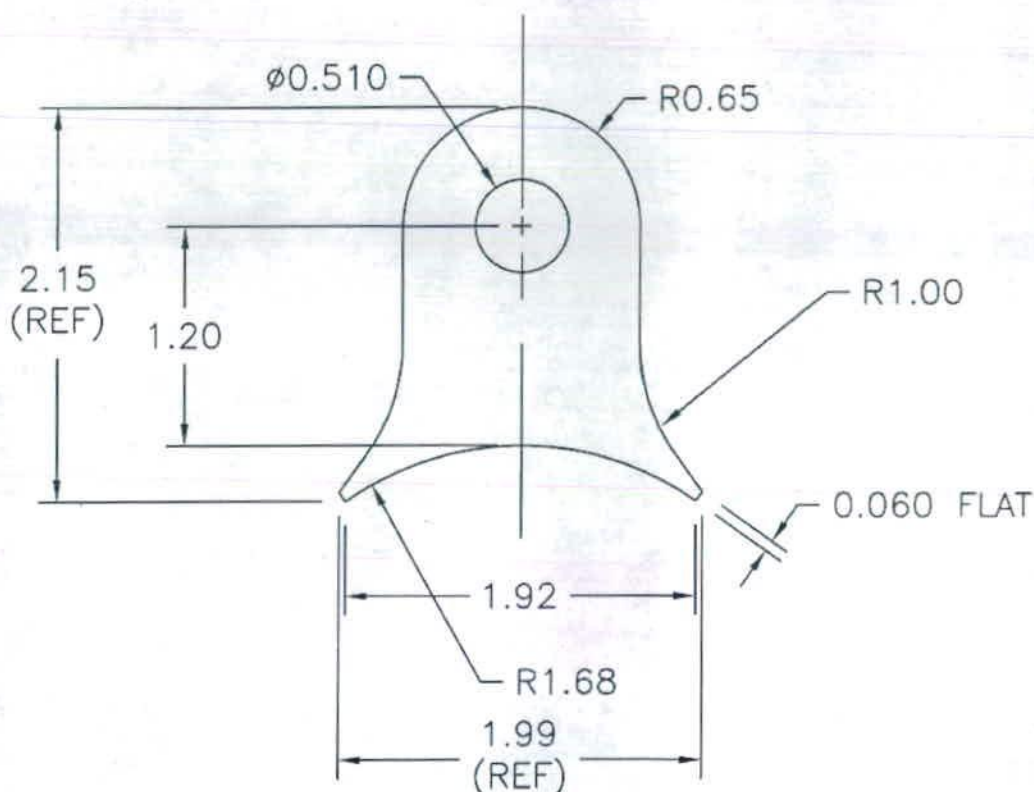
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DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1

RELEASED
05-07-06 [Signature]**D3414-3 LUG**

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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